



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB 92700-10308-041-4-PO

Job Sheet 185585



Part No: RB 92700-10308-041-4-PO **Job Qty:** 3 ea

Part Name: Input Module Seal Installer Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/30/18

Job Tracking No:

Due Date: 12/14/18

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RB 92700-10308-041 Rev.A IPP Rev. A 18.10.29 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	3 pcs		12/14/18	0.00	0.00	Purchasing		DEC 28 2018
110	Packaging	3 pcs		12/14/18	0.00	0.00	Packaging2		DEC 28 2018
120	QC	3 pcs		12/14/18	0.00	0.00	QC6		61
130	Small Fab	3 pcs		12/14/18	0.00	0.30	Small Fab-2		9-89
140	QC	3 pcs		12/14/18	0.00	0.00	QC5		
150	Packaging	3 pcs		12/14/18	0.00	0.00	Packaging3		DEC 31 2018
160	QC21-FG	3 Ea		12/14/18	0.00	0.00	QC21		70

Part Op 100 - Issue P/O: 041341 MANUFACTURE RBW6305G23631-3G AS PER DWG Supplier: ARROW TECH MACHINE
Descriptions: WORKS -Certificate of conformity is required
130 - Re-identify as required.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB 92700-10308-041-4P	Input Module Seal Installer Assembly	3 (1 ea)	100-Purchasing	5140664

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RB 92700-10308-041-4P	3	0	0

Part Specifications



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Not found.

Plex 10/30/18 2:48 PM dart.Lussier.Patrick

Container No: S140665



Part: RB 92700 - 10308 - 041 - 4

Job No: 185585

Serial No/Batch: S140665

Revision: A

Inspector:

Exp Date:

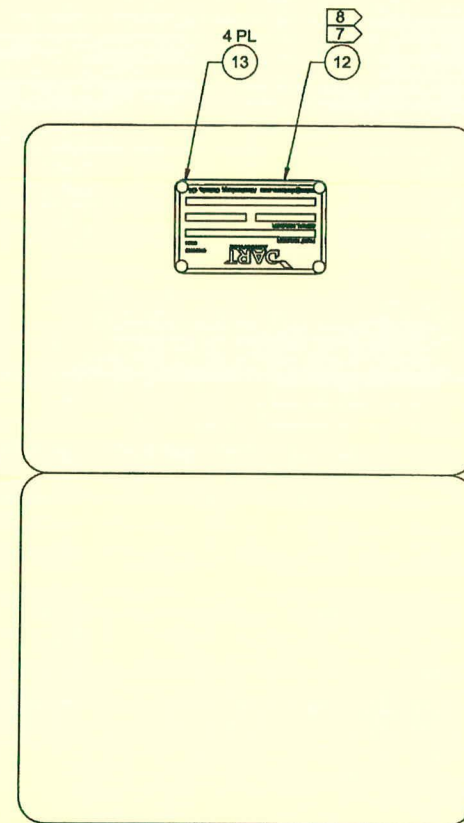
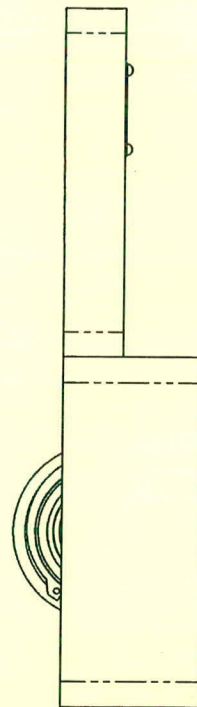
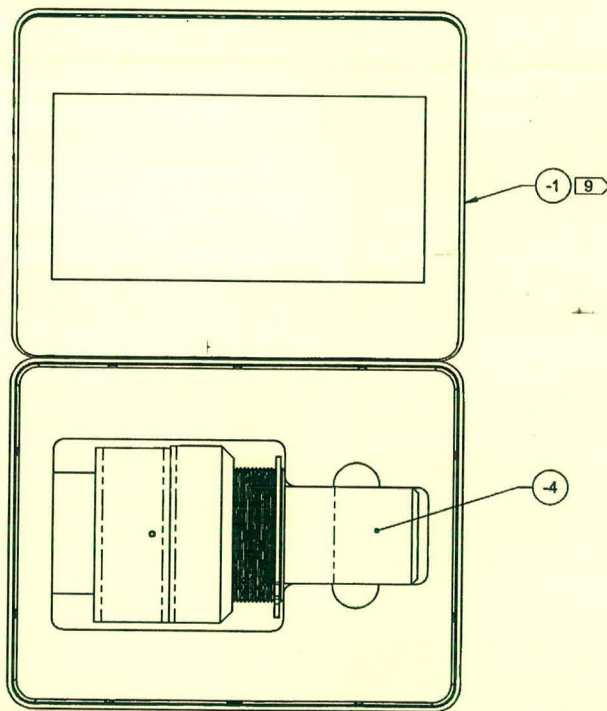
Instructions:

Date: 12/28/18

DEC 14 2018
DEC 14 2018

DEC 14 2018
DEC 14 2018
DEC 14 2018

ITEM #	QTY	PART #	PART TITLE
-1	1	RB 92700-10308-041-1	PACKAGING ASSY
-4	1	RB 92700-10308-041-4	INPUT MODULE SEAL INSTALLER ASSY
12	1	RB41011	DART PLACARD
13	4	McMaster#97524A032 OR EQUIV.	ALUMINUM SEALING BLIND RIVETS 1/8" DIA. x 0.425" LG.



RB 92700-10308-041 INPUT MODULE SEAL INSTALLER

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A

- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"
- X.XX = +/- 0.01" / +/- 0.5"
- X.XXX = +/- 0.005" / +/- 0.1"
- X.XXXX = +/- 0.0005" / +/- 0.05"

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED

- 6) BREAK SHARP EDGES: N/A

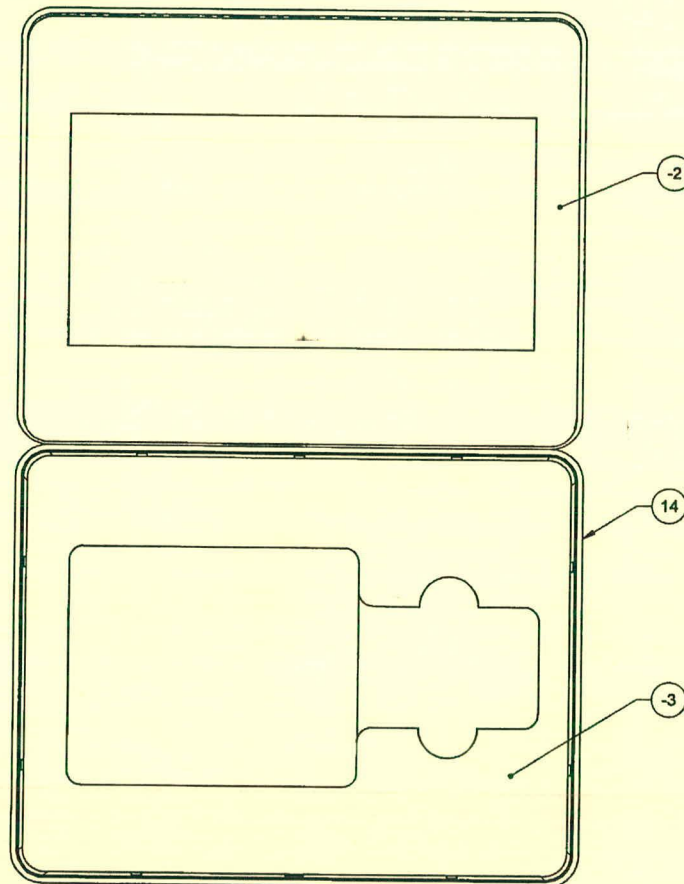
- 7) IDENTIFICATION: ENGRAVE THE TOOL P/N & S/N ON THE DART PLACARD WHERE INDICATED

- 8) INSTALL THE DART PLACARD ONTO THE TOP OF THE CASE IN AVAILABLE AREA USING ALUMINIUM POP RIVETS

- 9) HOT GLUE THE TOP AND BOTTOM FOAM INTO THE CASE

A	NEW ISSUE	18-632	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10308-041	SHEET 1 OF 12
APPROVED	<i>MBL</i>	TITLE	SCALE
		INPUT MODULE SEAL INSTALLER	NTS
DATE	6/25/2018	COPYRIGHT © 2018 BY DART AEROSPACE LTD	
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ITEM #	QTY	PART #	PART TITLE
-2	1	RB 92700-10308-041-2	TOP FOAM
-3	1	RB 92700-10308-041-3	BOTTOM FOAM
14	1	PELICAN #APP-1200-E	PELICAN CASE 1200



RB 92700-10308-041-1 PACKAGING ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A

- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"
- X.XX = +/- 0.01" / +/- 0.5"
- X.XXX = +/- 0.005" / +/- 0.1"
- X.XXXX = +/- 0.0005" / +/- 0.05"

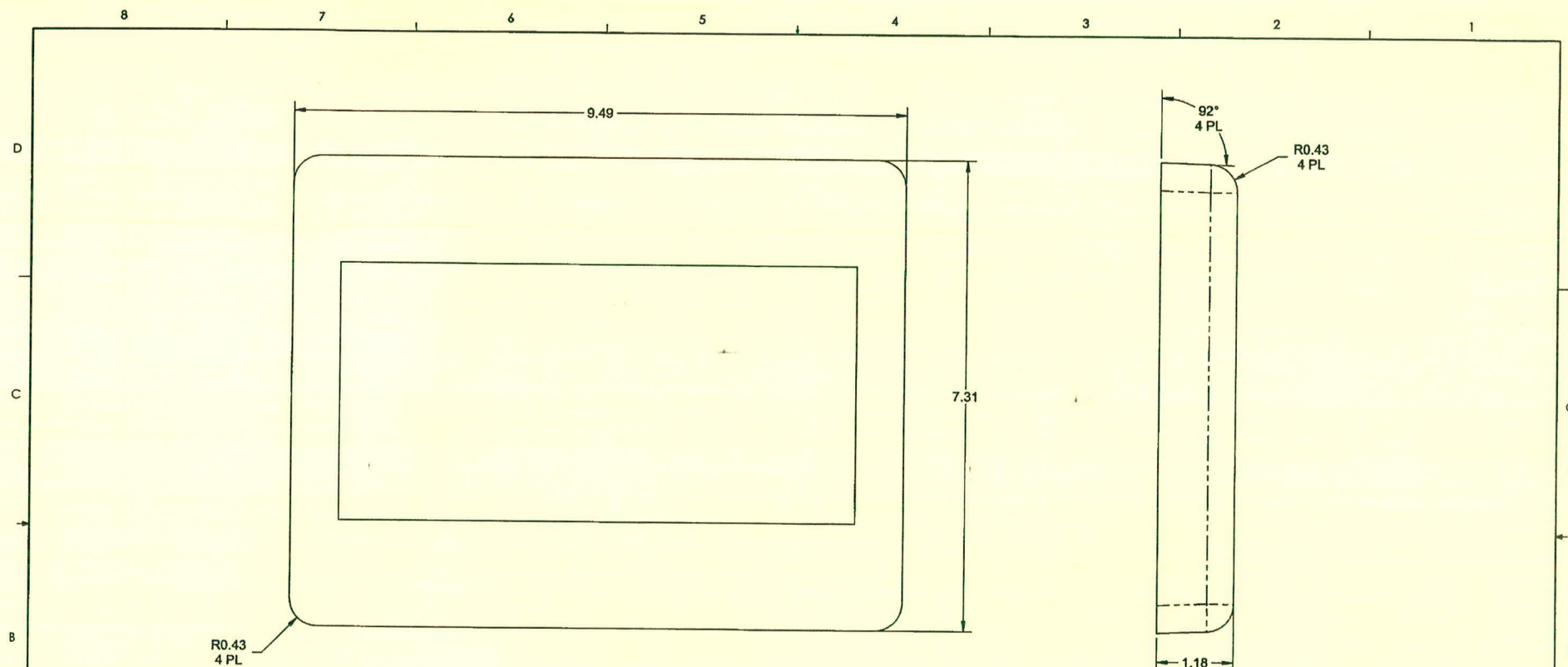
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED

- 6) BREAK SHARP EDGES: N/A

- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10308-041	SHEET 2 OF 12
APPROVED	<i>W Lee</i>	TITLE	SCALE
		INPUT MODULE SEAL INSTALLER	NTS
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RB 92700-10308-041-2 TOP FOAM

8

NOTES:

1) MATERIAL: BLACK ETHAFOAM 220

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1^\circ$
 X.XX = $\pm 0.01"$ / $\pm 0.5^\circ$
 X.XXX = $\pm 0.005"$ / $\pm 0.1^\circ$
 X.XXXX = $\pm 0.0005"$ / $\pm 0.05^\circ$
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$

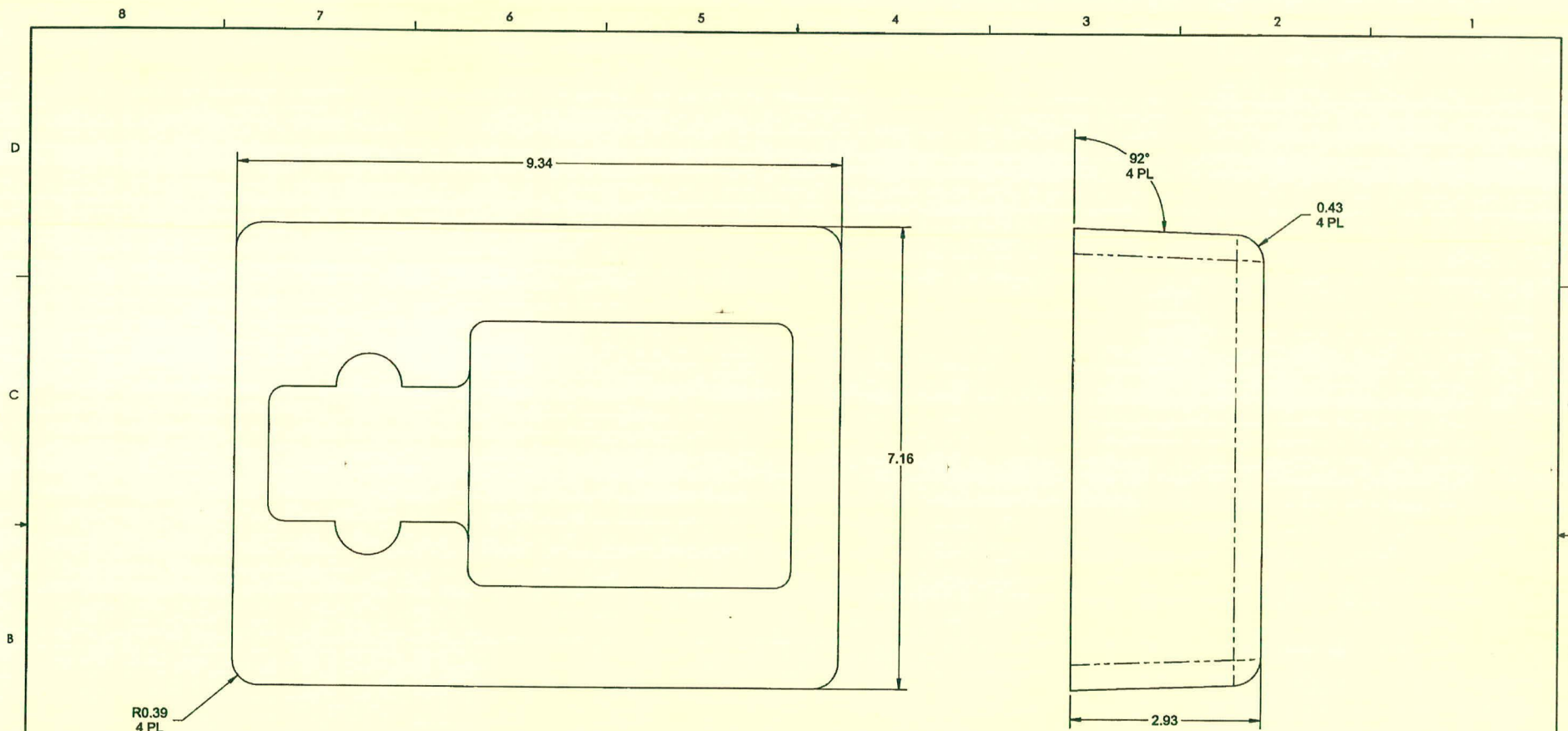
5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: N/A

7) IDENTIFICATION: N/A

8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF $\pm 0.050"$ PER CAD FILE RB 92700-10308-041-2

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10308-041	SHEET 3 OF 12
APPROVED	<i>M. Lee</i>	TITLE	SCALE
		INPUT MODULE SEAL INSTALLER	NTS
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RB 92700-10308-041-3 BOTTOM FOAM

8

NOTES:

1) MATERIAL: BLACK ETHAFOAM 220

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1"

X.XX = +/- 0.01" / +/- 0.5"

X.XXX = +/- 0.005" / +/- 0.1"

X.XXXX = +/- 0.0005" / +/- 0.05"

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

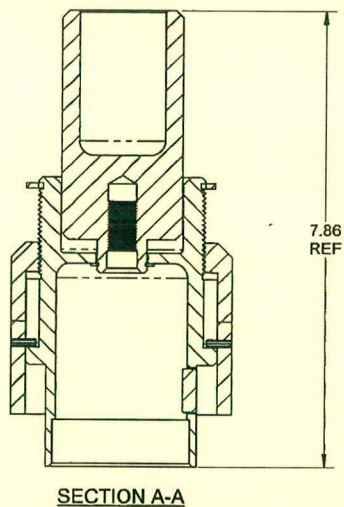
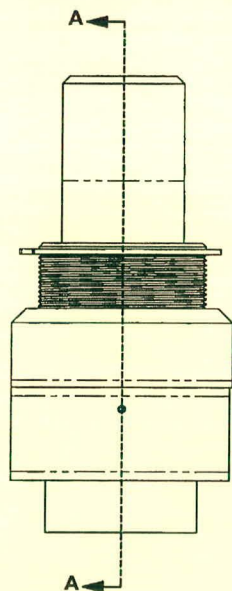
6) BREAK SHARP EDGES: N/A

7) IDENTIFICATION: N/A

8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.050" PER CAD FILE RB 92700-10308-041-3

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10308-041	SHEET 4 OF 12
APPROVED	<i>VM</i>	TITLE	SCALE
		INPUT MODULE SEAL INSTALLER	NTS
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ITEM #	QTY	PART #	PART TITLE
-5	1	RB 92700-10308-041-5	PUSHER
-6	1	RB 92700-10308-041-6	SEAL INSTALLER ASSY
-9	1	RB 92700-10308-041-9	ALIGNMENT RING ASSY
-11	1	RB 92700-10308-041-11	THREADED RING
15	1	McMaster#97633A475 OR EQUIV	EXTERNAL RETAINING RING FOR 2-7/8" OD.
16	1	McMaster#97633A270 OR EQUIV	STEEL EXTERNAL RETAINING RING FOR 7/8" OD.



RB 92700-10308-041-4 INPUT MODULE SEAL INSTALLER ASSY 9

NOTES:

- 1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A

- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

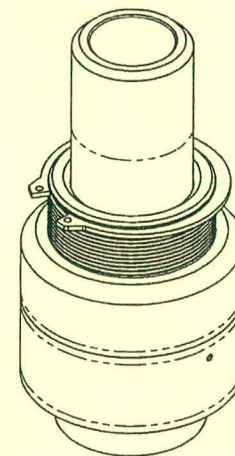
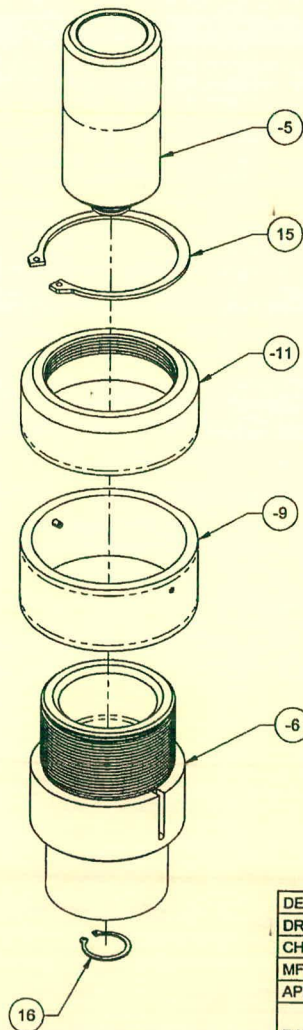
5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: N/A

7) IDENTIFICATION: N/A

8) ASSEMBLE AS SHOWN

9) THE TOOL MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG



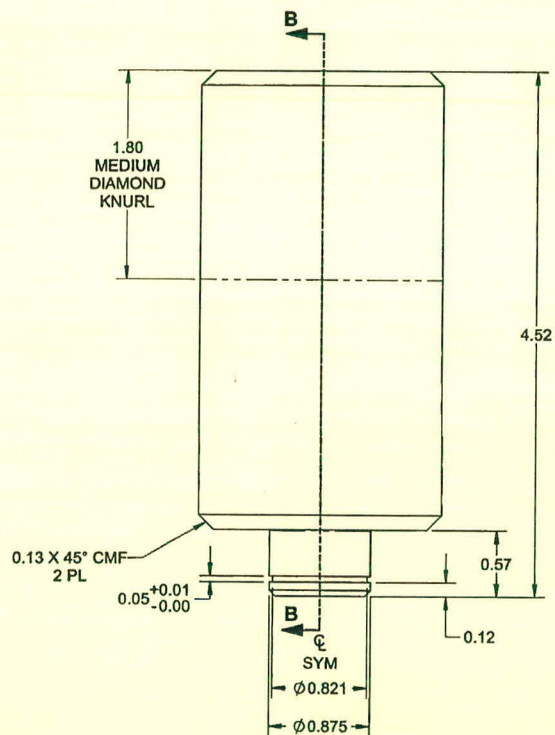
DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10308-041	SHEET 5 OF 12
APPROVED	<i>McLee</i>	TITLE	SCALE
		INPUT MODULE SEAL INSTALLER	NTS
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8 7 6 5 4 3 2 1

D

C

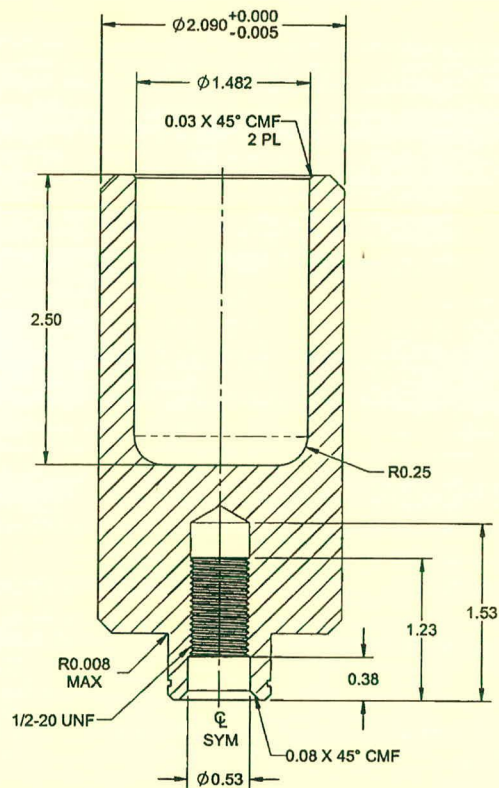
B



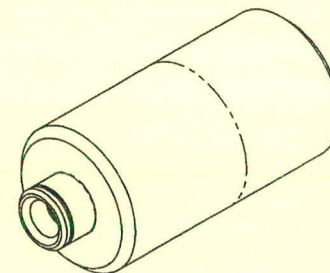
RB 92700-10308-041-5 PUSHER

NOTES:

- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"
 X.XX = +/- 0.01" / +/- 0.5"
 X.XXX = +/- 0.005" / +/- 0.1"
 X.XXXX = +/- 0.0005" / +/- 0.05"
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: N/A



SECTION B-B



D

C

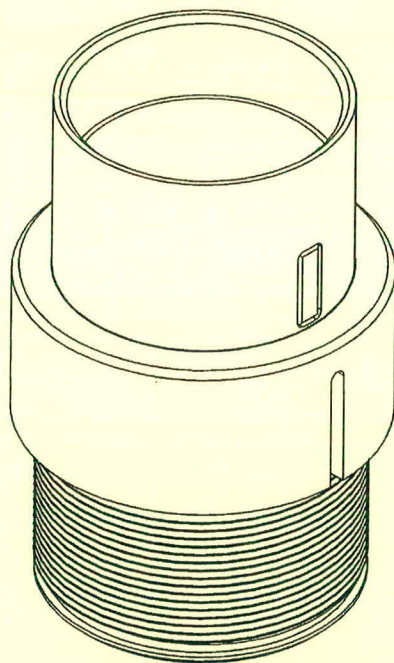
B

A

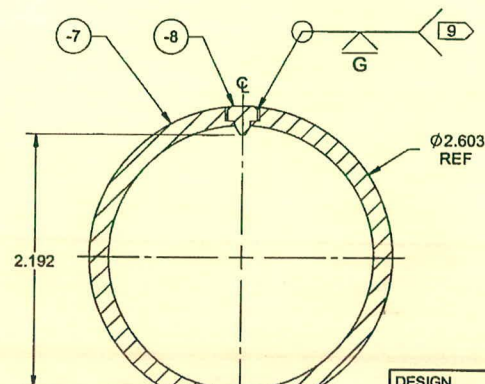
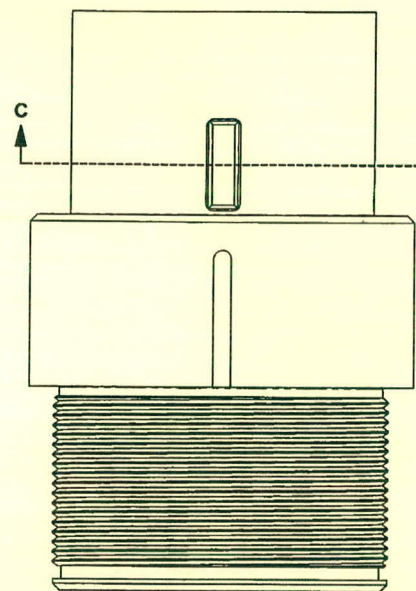
DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10308-041	SHEET 6 OF 12
APPROVED	<i>VM</i>	TITLE	SCALE
		INPUT MODULE SEAL INSTALLER	NTS
DATE 6/25/2018		COPYRIGHT © 2018 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

ITEM #	QTY	PART #	PART TITLE
-7	1	RB 92700-10308-041-7	SEAL INSTALLER
-8	1	RB 92700-10308-041-8	GEAR ALIGNMENT



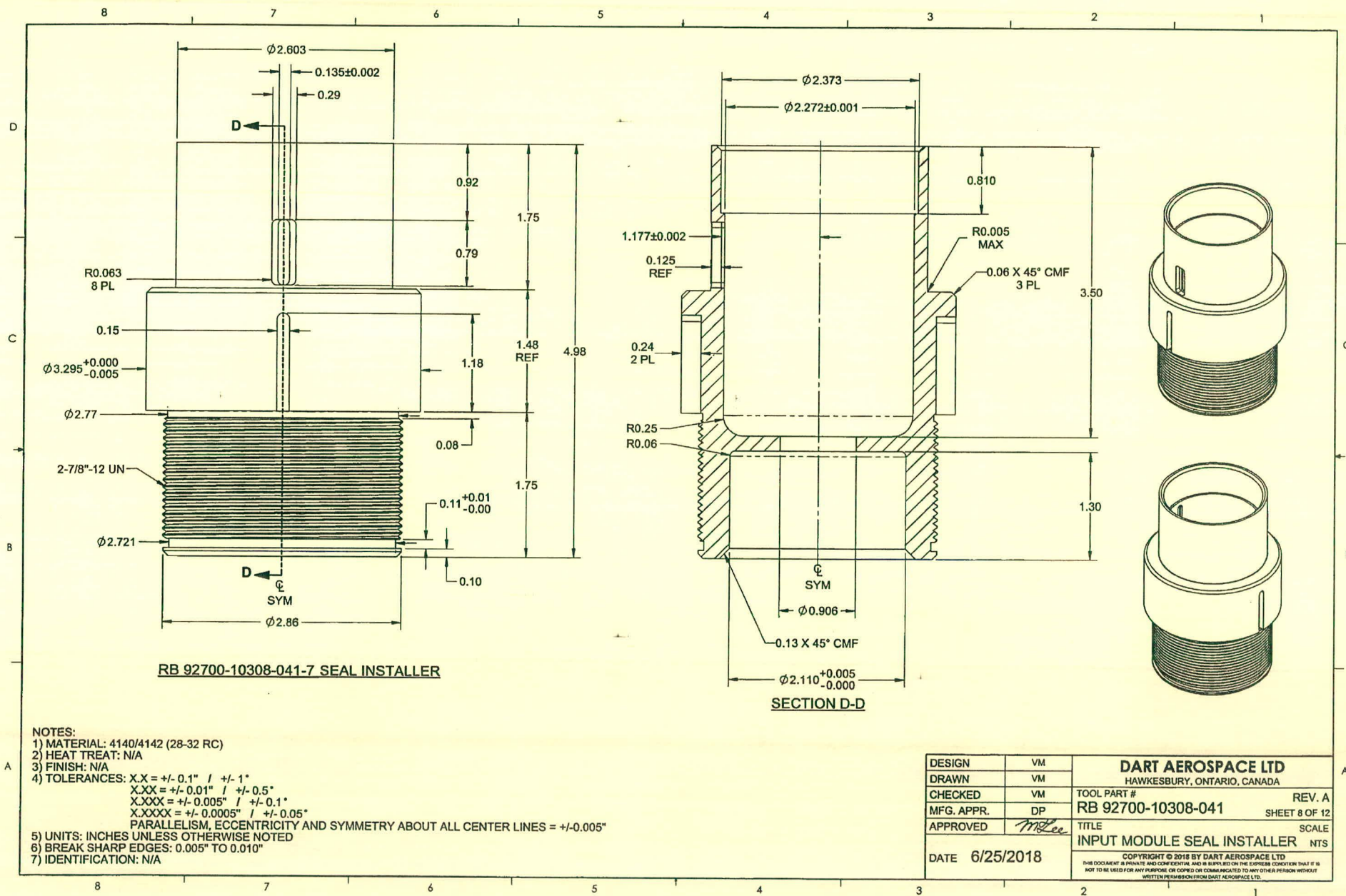
RB 92700-10308-041-6 SEAL INSTALLER ASSY

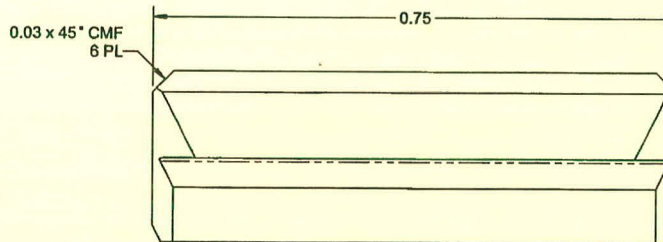
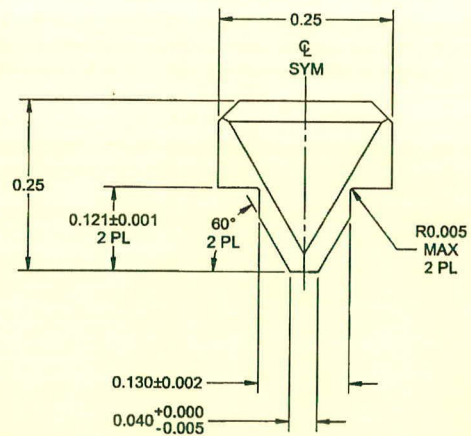


SECTION C-C

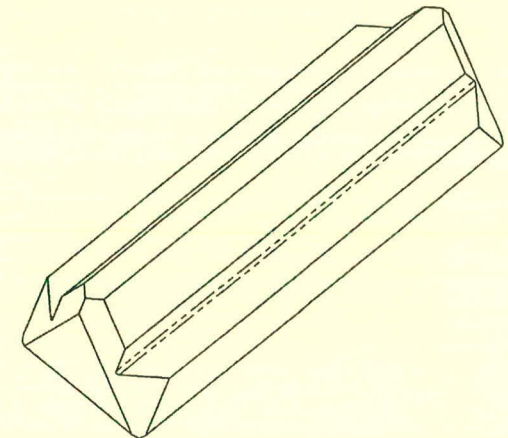
- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
 - 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1^\circ$
X.XX = $\pm 0.01"$ / $\pm 0.5^\circ$
X.XXX = $\pm 0.005"$ / $\pm 0.1^\circ$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: N/A
 - 7) IDENTIFICATION: N/A
 - 8) ASSEMBLE AS SHOWN
 - 9) GRIND OR MACHINE WELD FLUSH TO SURFACE OF ITEM -7

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10308-041	SHEET 7 OF 12
APPROVED	<i>M. Lee</i>	TITLE	SCALE
		INPUT MODULE SEAL INSTALLER	NTS
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RB 92700-10308-041-8 GEAR ALIGNMENT



NOTES:

1) MATERIAL: 4140/4142 (28-32 RC)

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

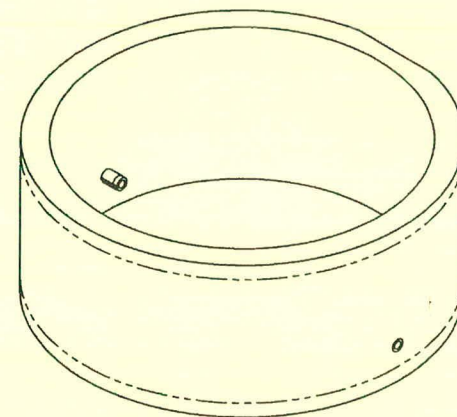
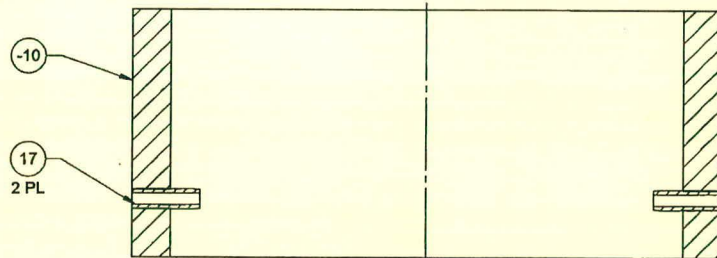
5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: 0.005" TO 0.010"

7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10308-041	SHEET 9 OF 12
APPROVED	<i>MDL</i>	TITLE	SCALE
		INPUT MODULE SEAL INSTALLER	NTS
DATE	6/25/2018	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM #	QTY	PART #	PART TITLE
-10	1	RB 92700-10308-041-10	ALIGNMENT RING
17	2	McMaster#90692A693 OR EQUIV	STEEL SPRING PIN 1/8" DIA. x 7/16" LG.

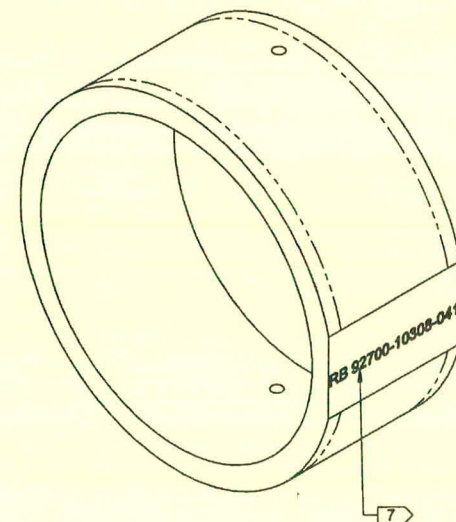
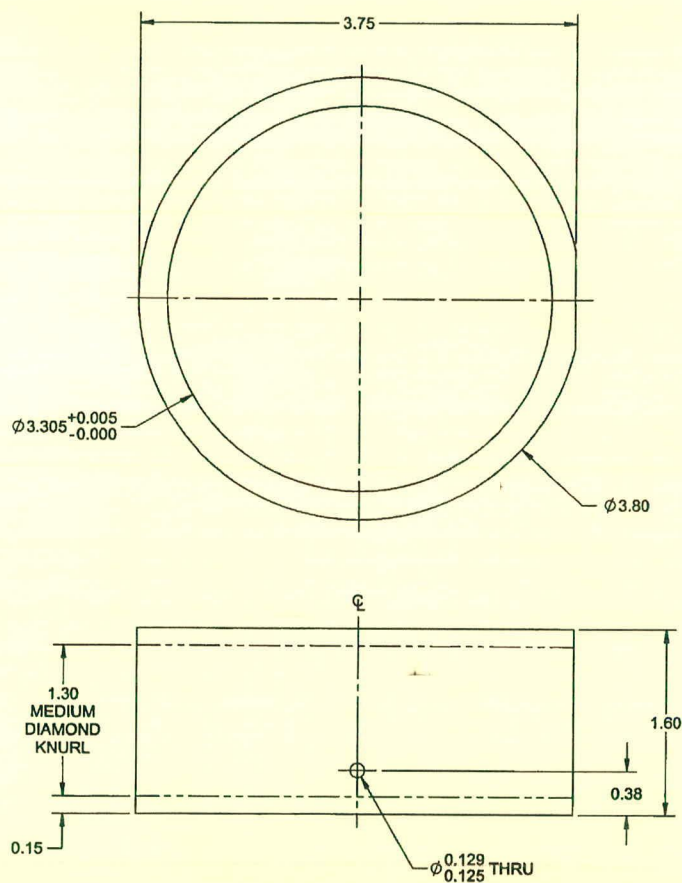


RB 92700-10308-041-9 ALIGNMENT RING ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) ASSEMBLE AS SHOWN

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10308-041	SHEET 10 OF 12
APPROVED	<i>MBL</i>	TITLE	SCALE
		INPUT MODULE SEAL INSTALLER	NTS
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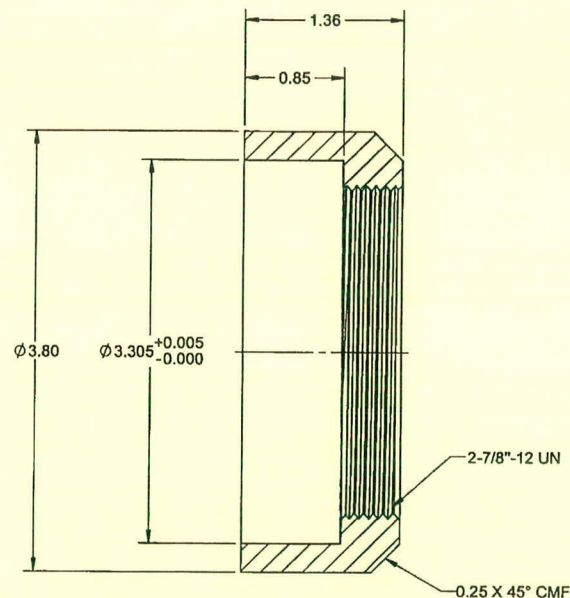
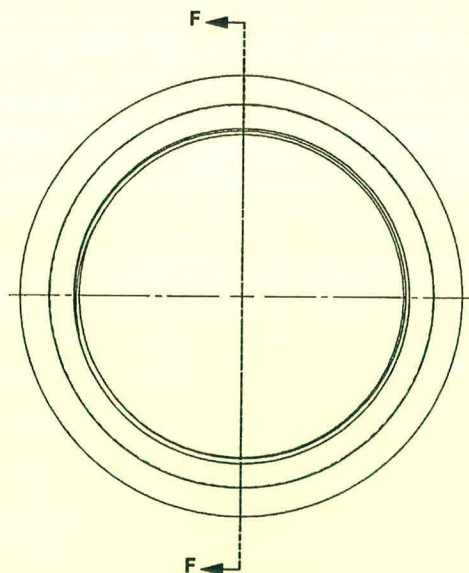
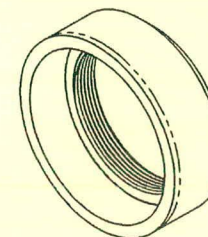
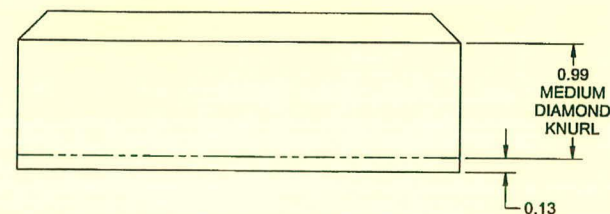


NOTES:

- 1) MATERIAL: 6061-T6 / 7075-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1"$
X.XX = $\pm 0.01"$ / $\pm 0.5"$
X.XXX = $\pm 0.005"$ / $\pm 0.1"$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05"$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: MACHINE ENGRAVE PER CAD MODEL AS SHOWN OR DOT MARK T/N AS SHOWN

RB 92700-10308-041-10 ALIGNMENT RING

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10308-041	SHEET 11 OF 12
APPROVED	<i>M. Lee</i>	TITLE	SCALE
		INPUT MODULE SEAL INSTALLER	NTS
DATE	6/25/2018	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



SECTION F-F

RB 92700-10308-041-11 THREADED RING

NOTES:

- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: XX = ± 0.1 " / $\pm 1^\circ$
 XXX = ± 0.01 " / $\pm 0.5^\circ$
 XXXX = ± 0.005 " / $\pm 0.1^\circ$
 XXXXX = ± 0.0005 " / $\pm 0.05^\circ$

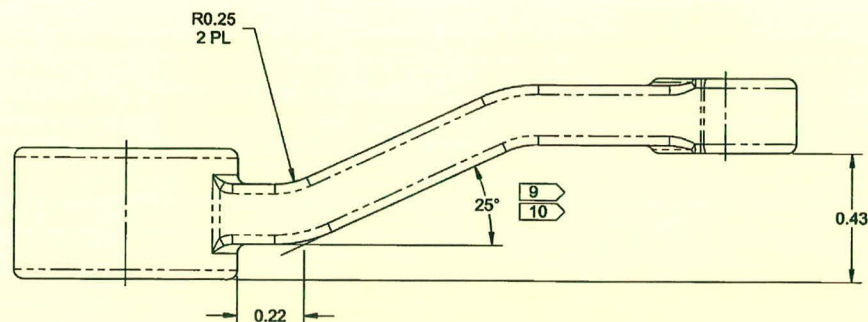
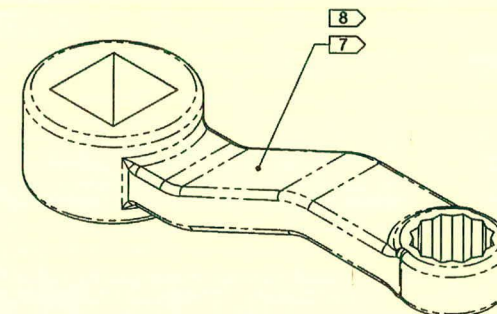
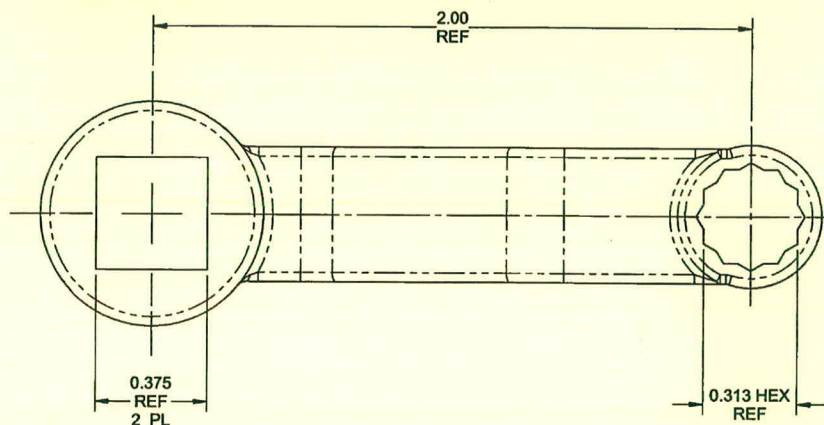
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = ± 0.005 "

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: 0.005" TO 0.010"

7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10308-041	SHEET 12 OF 12
APPROVED	<i>M. Lee</i>	TITLE	SCALE
DATE 6/25/2018		INPUT MODULE SEAL INSTALLER	NTS
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RB 92700-10750-101 TORQUE ADAPTER

NOTES:

- 1) MATERIAL: SNAP-ON#FRDH101 OR EQUIV
- 2) HEAT TREAT: N/A
- 3) FINISH: CHROME PLATE PER QQ-C-320 TYPE 2 CLASS 1
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"

X.XX = +/- 0.01" / +/- 0.5"
X.XXX = +/- 0.005" / +/- 0.1"
X.XXXX = +/- 0.0005" / +/- 0.05"

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: 0.005" TO 0.010"

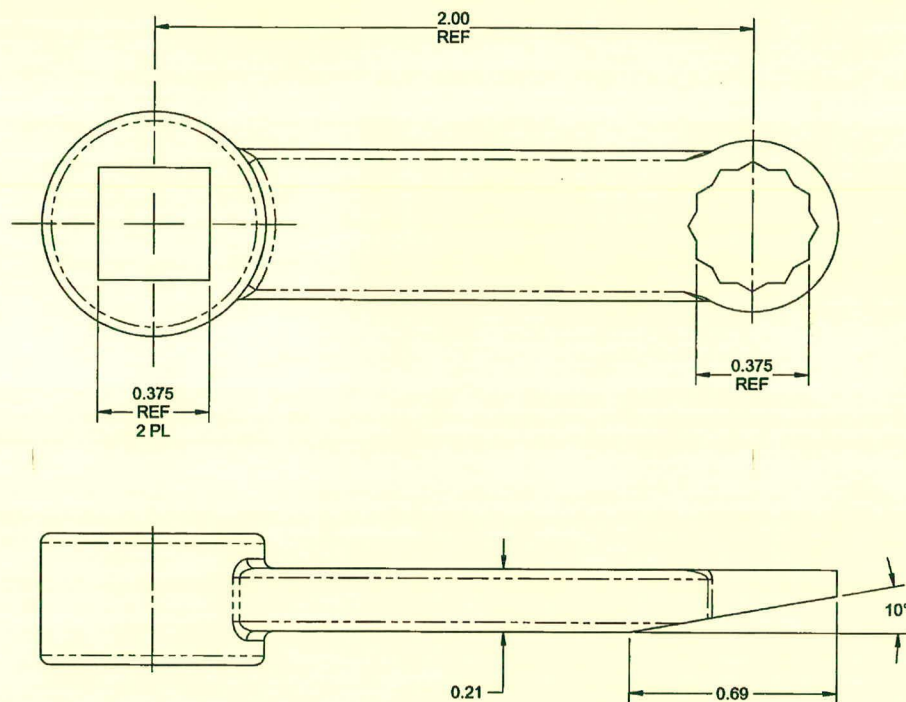
7) IDENTIFICATION: LASER ETCH OR BAG AND TAG PER QSI 044

8) REMOVE FACTORY MARKINGS ONLY IF NECESSARY

9) IT IS ACCEPTABLE TO REMOVE FACTORY FINISH PRIOR TO FABRICATION

10) PREHEAT PRIOR TO FORMING

REV.	NEW ISSUE	18-615	KT
DESIGN	KT	DESCRIPTION	BY
DRAWN	VM	DART AEROSPACE LTD	
CHECKED	MPL	HAWKESBURY, ONTARIO, CANADA	
MFG. APPR.	DP	TOOL PART #	REV. A
APPROVED	MPL	RB 92700-10750-101	SHEET 1 OF 1
DATE	6/5/2018	TITLE	SCALE
		TORQUE ADAPTER	NTS
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RB 92700-10750-102 TORQUE ADAPTER

NOTES:

1) MATERIAL: SNAP-ON#FRDH121 OR EQUIV

2) HEAT TREAT: N/A

3) FINISH: CHROME PLATE PER QQ-C-320 TYPE 2 CLASS 1

4) TOLERANCES: X.X = ± 0.1 " / $\pm 1^\circ$

X.XX = ± 0.01 " / $\pm 0.5^\circ$

X.XXX = ± 0.005 " / $\pm 0.1^\circ$

X.XXXX = ± 0.0005 " / $\pm 0.05^\circ$

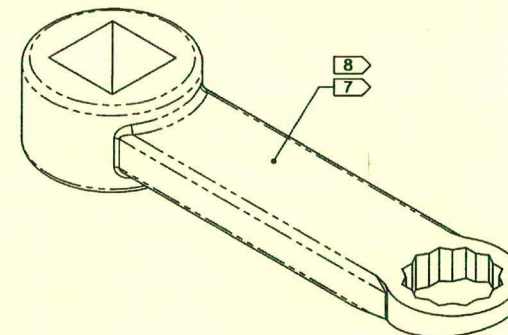
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = ± 0.005 "

5) UNITS: INCHES UNLESS OTHERWISE NOTED

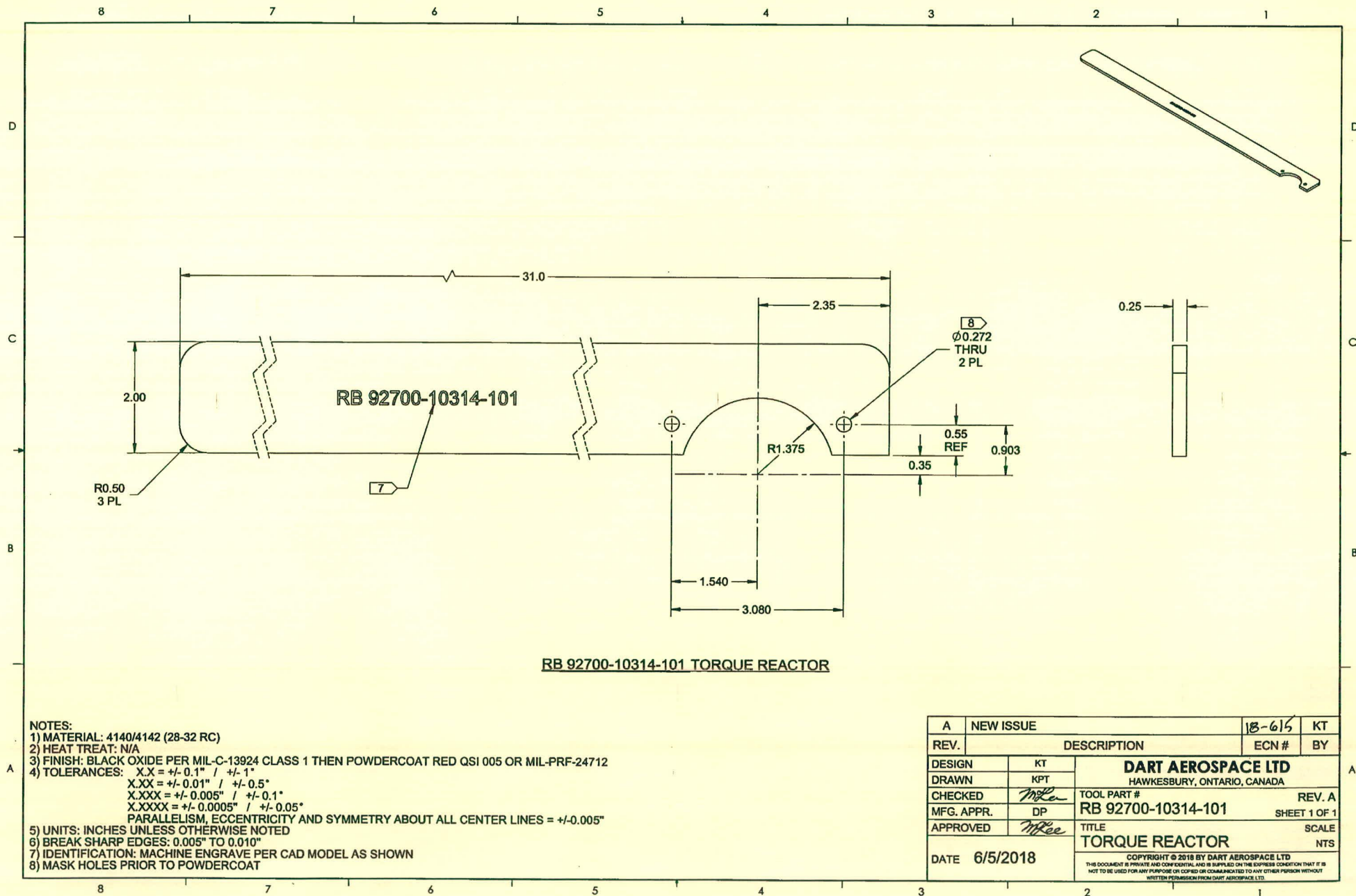
6) BREAK SHARP EDGES: 0.005" TO 0.010"

7) IDENTIFICATION: IDENTIFY PER QSI 044 METHOD 6.6 OR 6.7 OR 6.8

8) REMOVE FACTORY MARKINGS ONLY IF NECESSARY



A	NEW ISSUE	18-615	KT
REV.	DESCRIPTION	ECN #	BY
DESIGN	KT	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MLA	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10750-102	SHEET 1 OF 1
APPROVED	MLA	TITLE	SCALE
DATE	6/5/2018	TORQUE ADAPTER	NTS
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NOTES:

- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN POWDERCOAT RED QSI 005 OR MIL-PRF-24712
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"
X.XX = +/- 0.01" / +/- 0.5"
X.XXX = +/- 0.005" / +/- 0.1"
X.XXXX = +/- 0.0005" / +/- 0.05"
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: MACHINE ENGRAVE PER CAD MODEL AS SHOWN
- 8) MASK HOLES PRIOR TO POWDERCOAT

A	NEW ISSUE	18-615	KT
REV.	DESCRIPTION	ECN #	BY
DESIGN	KT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	Mee	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10314-101	SHEET 1 OF 1
APPROVED	Mee	TITLE	SCALE
DATE 6/5/2018		TORQUE REACTOR	NTS
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041341**

Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

PO No: PO041341
PO Date: 10/12/18
Due Date: 12/21/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Belanger, Natasha
Phone:
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Ship To:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
4	185585	RB 92700-10308-041-4P			Input Module Seal Installer Assembly REV A	Firmed	-	12/21/18	3 Ea	0 Ea	3 Ea	\$1,856.00/Ea	\$5,568.00
Line Item Note SIOP													
10	185621	RB 92700-10307-041P			TR Nut Wrench REV A	Firmed	-	12/21/18	1 Ea	0 Ea	1 Ea	\$1,694.00/Ea	\$3,388.00
Line Item Note SIOP													
11	185622	RB 92700-10301-041P			Pitch Beam Puller REV A	Firmed	-	12/21/18	3 Ea	0 Ea	3 Ea	\$0.01/Ea	\$0.03
Line Item Note SIOP													
12	185623	RB 92700-10329-041-4P			Removal Tool Assembly REV A	Firmed	-	12/21/18	3 Ea	0 Ea	3 Ea	\$1,543.00/Ea	\$4,629.00
Line Item Note SIOP													
16	185663	RB 92700-10334-042P			Engine Lifting Sling REV A	Firmed	-	12/21/18	3 Ea	0 Ea	3 Ea	\$0.01/Ea	\$0.03
Line Item Note SIOP													
17	185665	RB 92700-10355-101P			Torque Adapter REV A	Firmed	-	12/21/18	3 Ea	0 Ea	3 Ea	\$1,448.00/Ea	\$4,344.00
Line Item Note SIOP													



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041341**

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
18	185616	RB 92700-10349-041-5P			Handle Assembly REV A5	Firmed	-	12/21/18	3 Ea	0 Ea	3 Ea	\$998.00/Ea	\$2,994.00
Line Item Note SUB ASSY FOR TOP LEVEL RB 92700-10349-041													
19	185617	RB 92700-10349-041-8P			Seal Case Remover Assembly REV A5	Firmed	-	12/21/18	3 Ea	0 Ea	3 Ea	\$998.00/Ea	\$2,994.00
Line Item Note SUB ASSY FOR TOP LEVEL RB 92700-10349-041													
20	185618	RB 92700-10349-041-12P			Seal Ring Remover Assembly	Firmed	-	12/21/18	3 Ea	0 Ea	3 Ea	\$998.00/Ea	\$2,994.00
Line Item Note SUB ASSY FOR TOP LEVEL RB 92700-10349-041													
												Grand Total:	\$26,911.06

Order Notes

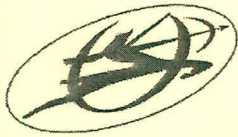
Procurement Quality Clauses
A005 RIGHT OF ENTRY
A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 12/21/18 2:18 PM dart.belanger.natasha



**PHGE Machineworks dba
Arrowtech Machineworks**
29751 E Enid Rd. Unit C
Eugene, Oregon 97402
Phone: (541) 780-6938
Fax: (458) 215-4938

Packing Slip

NO. 376

Date: 12/27/2018
PO Ref: 041341 ✓
Ship via: Fedex Priority

Bill To:
Dart Aerospace
1270 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K7

Ship To:
Dart Aerospace
1271 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K8

Qty	Item	Part No.
3 ✓	HANDLE ASSEMBLY	RB 92700-10349-041-5 ✓
3 ✓	SEAL CASE REMOVER ASSEMBLY	RB 92700-10349-041-8 ✓
3 ✓	SEAL RING REMOVER	RB 92700-10349-041-12 ✓
3 ✓	REMOVAL TOOL ASSEMBLY	RB 92700-10329-041-4 ✓
3 ✓	INPUT MODULE SEAL INSTALLER ASSEMBLY	RB 92700-10308-041-4 ✓
1	PITCH BEAM PULLER	RB 92700-10301-041
1	TR NUT WRENCH	RB 92700-10307-041

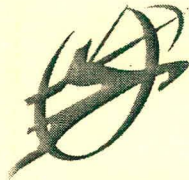
DAS
61
9-89

Received by: _____

Packaged by: AM

Checked by: CS

Thank You



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No: 041341 ✓

Dated: 12/27/2019

Our Order / Job No: 041341-4AWT

Order Qty: 3 ✓

Part Name: INPUT MODULE SEAL INSTALLER ASSY

Part Number: RB 92700 10308-041-4 ✓

Lot Size: N/A

Ship Date: 12/27/2019

DAS
61
9-89

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RB 92700-10308-041-4

Rev: A

Material Size and Type: -5, -7, -8, 11/4140 Q & T STEEL; -10/6061-T6 ALUM.

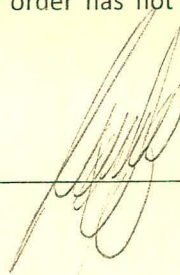
Material Specifications: STEEL: ASTM A108, ASTM A29; ALUM: ASTM NB209

Heat Treatment: N/A

Plating/Finish: RED ANODIZE: MILA-A-8625F TYPE 2 CLASS 2; BLACK OXIDE: QMSI-6.2.2
B.O. REV D

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 12/27/18

Signed: 

PHGE Machine Works LLC dba Arrow Tech Machine Works
29751 E. Enid Rd. Unit C Eugene, Oregon 97402
Main: (541) 780-6938 | Fax: (458) 215-4938
www.attechmachineworks.com

